Work Orde March-04-14 2:		266		*114	1266³	k		W 10 d					Page 1
Revision ID:	D3562-041			Accept	*N9	იი	040	100	ገ*	Setup	Start	*N;	S1*
		Start Qty: 2.00 Req'd Qty: 2.00	,		Cust I	1	D:				Stop	*N:	S2*
Approvals:	Process Plan QC:	:_MP	Date: 14 CB-OS Date:	Tooling: SPC (Y/N):		T	ate:			Run	Start Stop	^1\	R1* R <i>2</i> *
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool	ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr			•			- "					<u> </u>
D3562	F												
100 *1 \\ \tage Fab	:	Large Fab		0.00					2		٥_		<u>de</u> 14-03-1
Large Fab		2-Deburr	622 extrusion as per Dwg D35 and bevel ends for welding ans fer Hove's From										
¹¹⁰ *11∩*		QC6- Inspect dimensi	ons to drawing	0.00					2	f	J.		14.03.11
QC Quality Control		Мето		0.00						— - 7			14-03-11
120 *120*		Chemical Conversion	Coat per QSI005 4.1	0.00					P	ے	W.	143	M
HandFinish		Memo		0.00					ot-		ray	173	

Hand Finishing

DQA:		:	Date:										_	$^{\mathcal{L}}$ aaa $^{\mathcal{L}}$
		;				WORK ORDER NON-	-CC	ONFO	RMANCE / UPD			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Order	r:	!				DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
	-	· · · · ·				Rework	1		Skid-tube C	Crosstube		Water Jet		Engineering
Part No	ο.					Scrap	1)(Small Fab	Pro	d. Eng. Coor.		Quality
	_				_	Use-as-is		Therr	moforming	Finishing	Rec/Stor	e/Packaging		Other
NCR No	o					Suspected Unapproved]		Large Fab C	omposite		Supplier		
Root			·		Desci	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descripti	on	Date	Verification	٦	QC Inspector
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		Bending Centre No	t Canson	+=:0	-	BOM/Route	\vdash	1	Program	_	Outside Dim	ŀ	_	Pressure/Forced
-	\dashv	Cracks	ot concen	itiic		Broken/Damage/Defect	\vdash	Grain		-	Over/Under Part Incorred	ŀ		Set-up
-	—	Cracks Crimp/Kir	k/Pinnlo	/\^/		Burrs	\vdash	Hardwa	are tion Incomplete/Unqua	alified	1	1		Femperature/Cure
	_	Cuffs	ik/ kihbie/	vvave	-	Contamination	\vdash	1			Part Lost/Mi	ssing	\dashv	Weld
-	_	Crushing			-	Countersink	-	4	tions Incomplete/Uncle gned/off center	ear	Part Moved Positioned W	lrong ('	Wrong Stock Pulled
-		Heat Trea	t			Cut Too Short	-	Mislabe	-	<u> </u>	Positioned w	· .	\neg ,	Other
-	-	Inspection		Tube	 	Drawing	\vdash	Misrea			Jrower Loss/:	onige [10	Juici
	-	Marks/Ch	•	Tube	\vdash	Drill Holes	\vdash	Off-set						
-	\dashv	Turning S			-	Finish	\vdash	-	Calibration					
		Wave/Tw		e		Fit/Function	\vdash	-	Sequence					

Work Orde		4266		*112	1266 ²	t							Page	2
Item ID: Revision ID:	D3562-041			Accept	*N9(ററ	040	100)*		start	*N	S1*	
Item Name:	Step Weldmen	t								2	Stop	*N	S2*	
Start Date: Required Date:	25/03/2014 25/03/2014	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust I Custo	1):							
Reference:			-											
Approvals:	Process Pla	n:	Date:	Tooling:		Dat	te:		F		tart	*N	R1*	
	QC:	, wanted	_ Date:	SPC (Y/N):		_ Dat	te:			3	Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool	ID	Tool #	Plan Code	Accept Qty	Reject Qty		leject lumber	Insp. Stamp	
130		QC7-Inspect Chemical C	Conversion Coat	0.00					-				DAS	
1 30 QC Quality Control		Мето		0.00			` ` `		_2	<u> </u>			19 14 03	
140				0.00										
1 <u>4</u> 0		Small Fab							_2		>		Ac	14-03-
Small Fab		Memo		0.00									,	_
Small Fab		1- Transfer	drill Rivet holes as per d	wg D3562.										
		2-Touch-up	rivet holes with alodine	as per dwg d3562									•	
		3-Rivet legs	s using Scotch-Weld as p	er dwg D3562.										
		*****Ens	ure to wipe off any exess	magnobond *****										

A/R Scotch-Weld DP460
Batch: 126005
EXP DATE: 14-05-01

DQA:	· · · ·	_ Date:				_							`	TRAAG ²
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		14/	ork Order ug	odata only - F	_	AEROSPACE
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	- :				Rework			Skid-tube	Crosstube		1	Water Jet [Engineering
Part N	lo. ;				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	ヿ	Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite]	Supplier		
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Cause	Date	Step	Qty	Desci	or non-conformance		nief Eng		ription		Date	Verification		QC Inspector
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-		lot Conce	ntric		BOM/Route	L	Grain			_	Over/Under			et-up
-	Cracks			-	Broken/Damage/Defect		Hardwa			_	Part Incorre	-	—1	emperature/Cure
-		ink/Ripple	e/Wave	\vdash	Burrs		┫. `	on Incomplete/U	-	ļ	Part Lost/Mi	ssing	_	Veld
}	Cuffs!			-	Contamination	<u> </u>	-	ions Incomplete/l	Unclear	<u> </u>	Part Moved	L		Vrong Stock Pulled
}	Crushing			-	Countersink	_	4 -	ned/off center		<u> </u>	Positioned V		\neg_{\sim}	MI
}	Heat Tre		Tubo	-	Cut Too Short	\vdash	Mislabe			<u> </u>	Power Loss/	ourge [ΙO	ther
}	Marks/C	on Strip in	rupe	-	Drawing Drill Holes	\vdash	Misread Off-set	ı						
		natter Sequence			Finish	\vdash	4	Calibration						
		sequence wist in Tul		<u> </u>	Fit/Function	\vdash	-	Sequence						
	Ivvave/ I	WISCHE FU	ue .		i igi unction	1	Tout or :	equence						

Work Ord March-04-14 2		4266		*112	1266	*							Page 3
Item ID: Revision ID:	D3562-041			Accept	*N9	nn	040	100)* ·	Setup			S1*
Item Name:	Step Weldmen										Stop	*N:	S2*
Start Date: Required Date:	25/03/2014 25/03/2014	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*			Item l omer:	D:						
Reference: Approvals:	Process Pla	ın:	Date:	Tooling:		D	ate:	_	I	Run	Start	*N	R1*
ippi ovais.							ate:				Stop		R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Too	l ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
50		QC5- Inspect part compl	eteness to step on W/O	0.00					2		0		DAS
1 50 QC Quality Control		Memo		0.00					<u> </u>	(<u> </u>		DAS 19 14.03.14
60				0.00							A		
160		Large Fab							2	9			19
Large Fab		Memo	D 10560 0	0.00						l			V 52.14
arge Fab		per QSI 024 A/RAlumin	caps as per Dwg d3562 & um Rod <u>125/2</u> d cap welds flush as per Dw		eign objects as							Ae	14-03.14 14-03
170		QC10- Inspect visual per	r QSI004- ground welds	0.00									
170		Memo		0.00					2	¢			A

Memo

Quality Control

14.03-18 14.03-19 DAS 9 9-89

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	PDATE		_		AEROSPACE
QA Closed:		; 	Date:							W	ork Order up	date only		
Work Orde	er:	į				DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
	-	:			_	Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part N	lo.	1				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•	1				Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	No.	· · ·				Suspected Unapproved]		Large Fab	Composite]	Supplier[
Root					Desci	ription of work order update		nitial	Acti	on	Sign &			
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	_	Bending			Г	Bend	Г	Teolio/E	Program		Outside Dim	ensions [Pressure/Forced
	H	· -	ot Concer	ntric	<u> </u>	BOM/Route	-	Grain			Over/Under	· · · · · · · · · · · · · · · · · · ·		Set-up
		Cracks				Broken/Damage/Defect	H	Hardwa	are		Part Incorred	ł ·		Temperature/Cure
		Crimp /Kiı	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing		Weld
		Cuffs	- • •			Contamination		4	tions Incomplete/U	· —	Part Moved		_	Wrong Stock Pulled
		Crushing				Countersink		- 4	ned/off center		Positioned V	ا Vrong		•
		Heat Trea	at			Cut Too Short	-	Mislabe			Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	Sequence			Finish		Out of	Calibration					
		Wave/Tw	vist in Tub	oe		Fit/Function		Out of	Sequence					

Work Order ID 1	14266
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114266 Page 4 March-04-14 2:59:43 PM Item ID: D3562-041 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Step Weldment *2* **Start Date:** 25/03/2014 Start Oty: 2.00 Cust Item ID: **Required Date: 25/03/2014** Req'd Qty: 2.00 *9* **Customer:** Reference: Run Start Process Plan: _____ Date: Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description** Code Qty Qty **Run Hours** Number Stamp 180 QC5- Inspect part completeness to step on W/O 0.00 *120* 2) 140315 OC 0.00 Memo Quality Control 190 Chemical Conversion Coat per QSI005 4.1 0.00 *100* HandFinish 0.00 Memo Hand Finishing White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum 200 0.00 Powdercoat 0.00 Memo START TIME: **Powder Coating**

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FINISH TIME:

DQA:		i	Date:												
		į	0-4-			WORK ORDER NON-	-CC	ONFO	RMANCE / UP				г		AEROSPACE
QA Closed:			Date:		1		_	1			W	ork Order up	date only		
Work Ord	er:	· 				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	•	<u>.</u> i				Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part I	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
		:			_	Use-as-is	i I		noforming	Finishing		-	re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite]	Supplier		
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Cause	r	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	<u>1</u>	QC Inspector
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	Ť	Bending				Bend		 Folio/F	Program	1		Outside Dim	ensions	•	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under			Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorred	ł		Temperature/Cure
ļ		Crimp/Kir	nk/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Unc	qualified		Part Lost/Mi	ssing		Weld
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		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence						

Work Orde		4266		*114	1266	k						1	Page 5
Revision ID:	D3562-041 Step Weldmen	nt	1,10000	Accept	*N9	იიი	າ40	100)*	Setup	Start Stop	1.71	S1* S2*
Start Date: Required Date: Reference:	25/03/2014 25/03/2014	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust I Custo	tem ID mer:) ;					IV	17
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		_ Dat				Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center II 210 *21) ·	Operation Description Wing Walk as per dwg C	2SI005 4.4 Batch_	Set Up/ Run Hours (2.2 Gogy) 0.00	Tool	ID	Tool#	Plan Code	Accep Qty	Qty		Reject Number	Insp. Stamp
220 */ OC Quality Control		QC3- Inspect Part Finish Memo		0.00					2				// DAS 36 ////03/3/ 9-89
230 *230* Packaging Packaging		Identify as per dwg & St	ock Location:	0.00					dx				14/03/3/ 9-89

DQA:		<u> </u>	Date:												$\mathcal{L}_{\mathcal{A}}$
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	-	:			_	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	o.	į.				Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor.		Quality
	-				_	Use-as-is		Therr	moforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	o. -	<u>;</u>				Suspected Unapproved			Large Fab	Composite [Supplier		
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1	_	Bending			<u> </u>	Bend	<u></u>	- '	Program	<u> </u>		utside Dim			Pressure/Forced
	_	Centre No	ot Concer	ntric		BOM/Route	_	Grain		-	_ ^\	ver/Under	tolerance		Set-up
	_	Cracks				Broken/Damage/Defect		Hardwa		L	_	rt Incorre		_	Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspect	ion Incomplete/Unqu	ualified	Pa	irt Lost/Mi	ssing	_	Weld
	Cuffs					Contamination		-	tions Incomplete/Un	clear	_	irt Moved			Wrong Stock Pulled
	Crushing					Countersink	-	-	gned/off center			sitioned V	_		1
	Heat Treat					Cut Too Short		Mislabe		L	Po	wer Loss/	Surge	L	Other
	Inspection Strip in Tube					Drawing		Misrea							·
	Marks/Chatter					Drill Holes	L	Off-set			_				
	Turning Sequence					Finish		-	Calibration		_				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence						

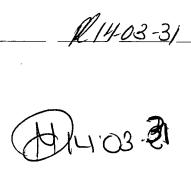
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Work Ord		4266		*112	1266	; *						Page 6
Item ID: Revision ID: Item Name:	D3562-041 Step Weldmer	nt		Accept	*No	മറ	140	100*	Setup	Start Stop	*NS	
Start Date: Required Date Reference:	25/03/2014 :: 25/03/2014	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*			t Item ID tomer:	:					
Approvals:	Process Pla	n:	_ Date:	Tooling: SPC (Y/N):		Dat			Run	Start Stop	*NF	
Sequence ID/ Work Center I	ID.	Operation Description OC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	То	ol ID	Tool#		ccept Re			Insp. Stamp

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Quality Control



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Root					Desc	ription of work order update	ı	nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	า	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
							FAI	ULT CAT	EGORY						
Landing	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/U ions Incomplete/ ned/off center eled	•		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Femperature/Cure Weld Wrong Stock Pulled Other
i		_	ist in Tub			Fit/Function	\vdash	4	Sequence						

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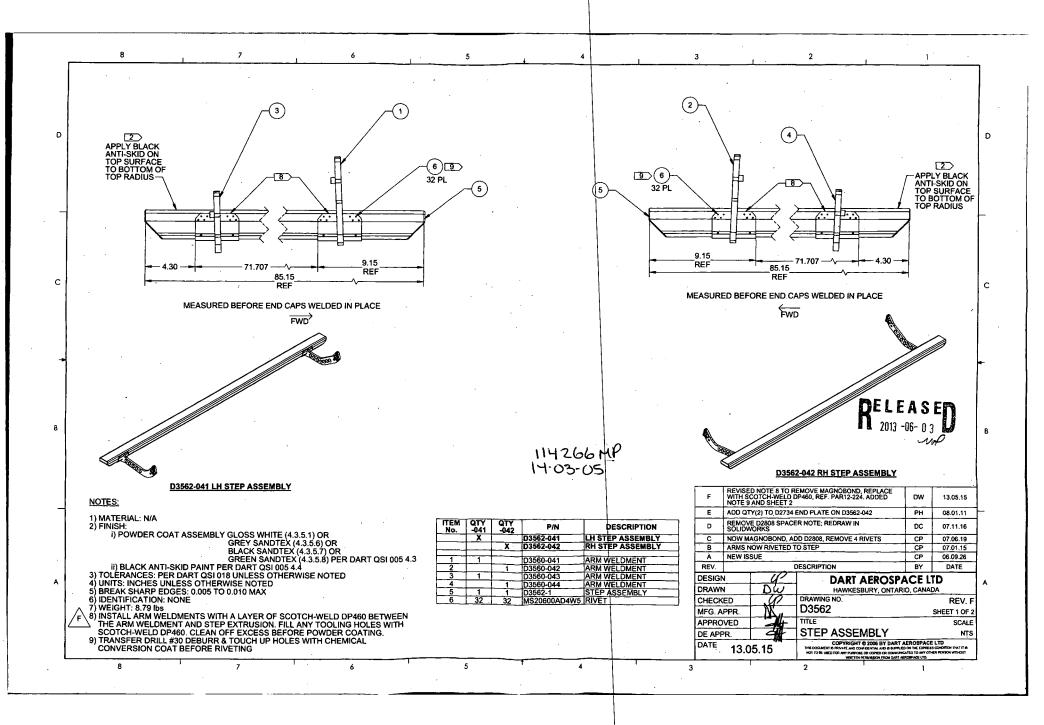
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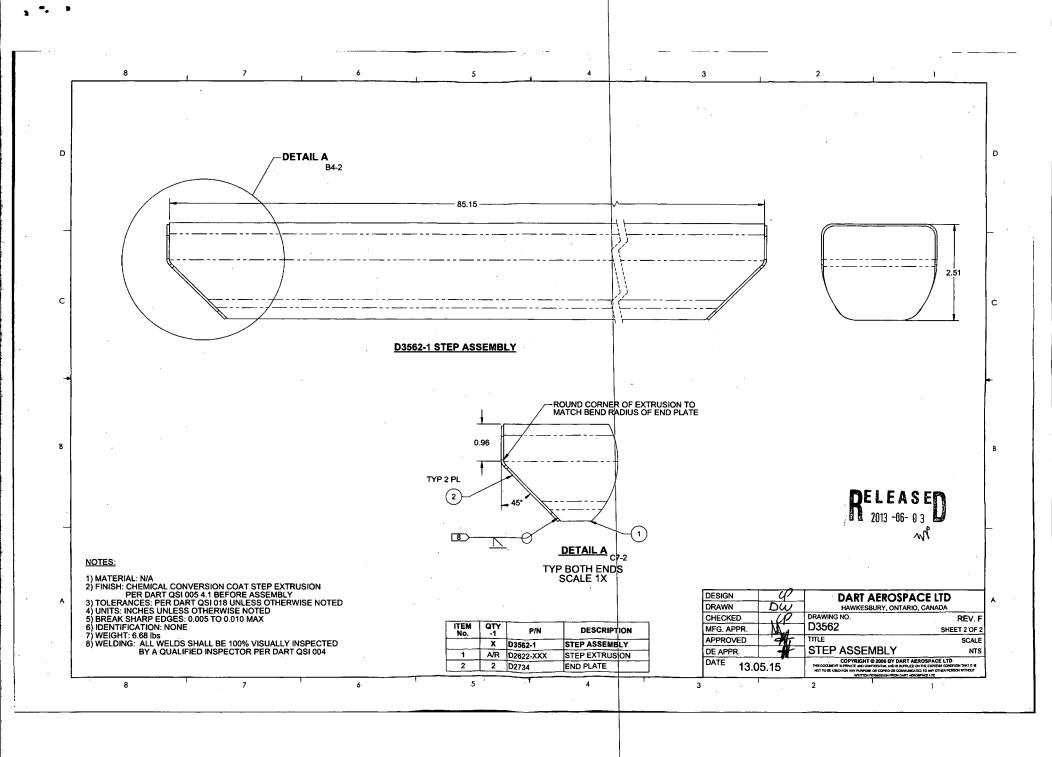
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		ı				WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		!	Date:							W	ork Order up	date only				
Work Orde	ır.	;				DISPOSITION										
Work Orde						Rework		Skid-tube	Crosstube	1	Water Jet		Engineering			
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	ļ	Quality		
	•					Use-as-is	1		noforming	Finishing	4	re/Packaging		Other		
NCR N	lo.	!				Suspected Unapproved	1		Large Fab	Composite	1	Supplier				
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Root					Desc	ription of work order update		Initial	Acti	on	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verificatio	n	QC Inspector		
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Work Order ID: 114266	*1	14266*	* + **********************************				
Parent Item: D3562-041 Parent Item Name: Step Weldment		3562-041*				t Date: 25/03/2014	Required Date: 25/03/2014
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